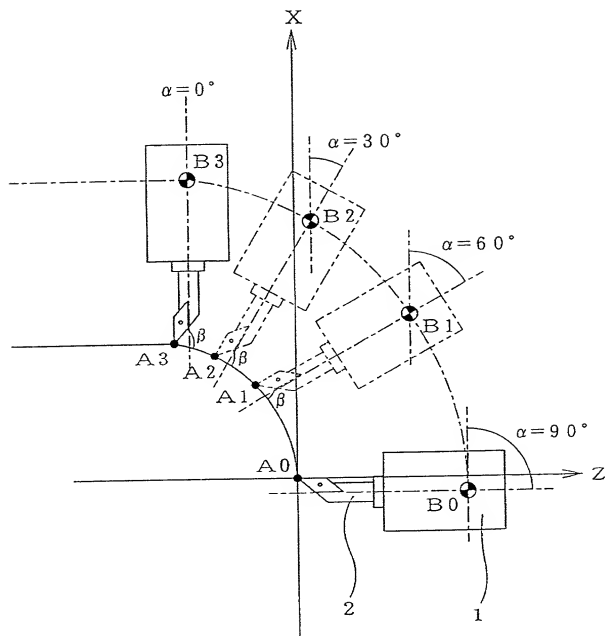


FIG. 1



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Fig. 2

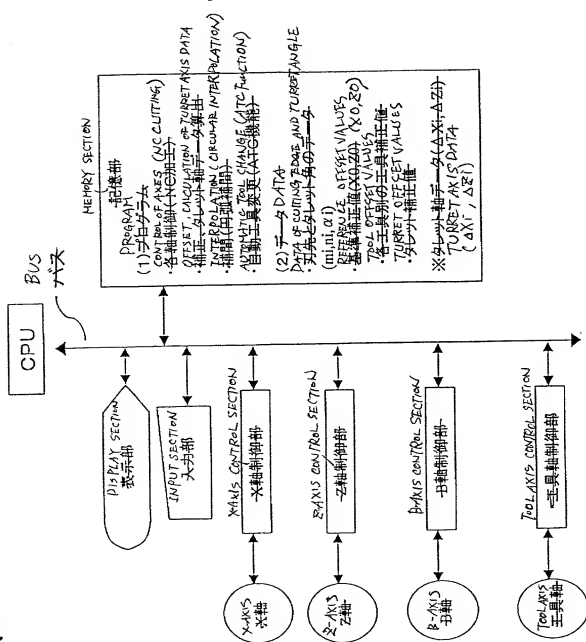


FIG. 3A

CUTTING EDGE CUTTING EDGE CUTTING EDGE  
POSITION DATA DATA DATA

刃先位置 *刃先位置	mi	ni	タレット角 $\alpha_i$
A0	0	0	90°
:	:	:	:
A1	20	-10	60°
:	:	:	:
A2	30	-20	30°
:	:	:	:
A3	35	-30	0°

TURRET AXIS  
POSITION

TURRET ANGLE

タレット軸位置	$\Delta X_i$	$\Delta Z_i$	タレット角 $\alpha_i$
B0	-5	40	90°
:	:	:	:
B1	35.7	27.1	60°
:	:	:	:
B2	62.1	4.3	30°
:	:	:	:
B3	75	-25	0°

FIG. 3B

FIG. 4

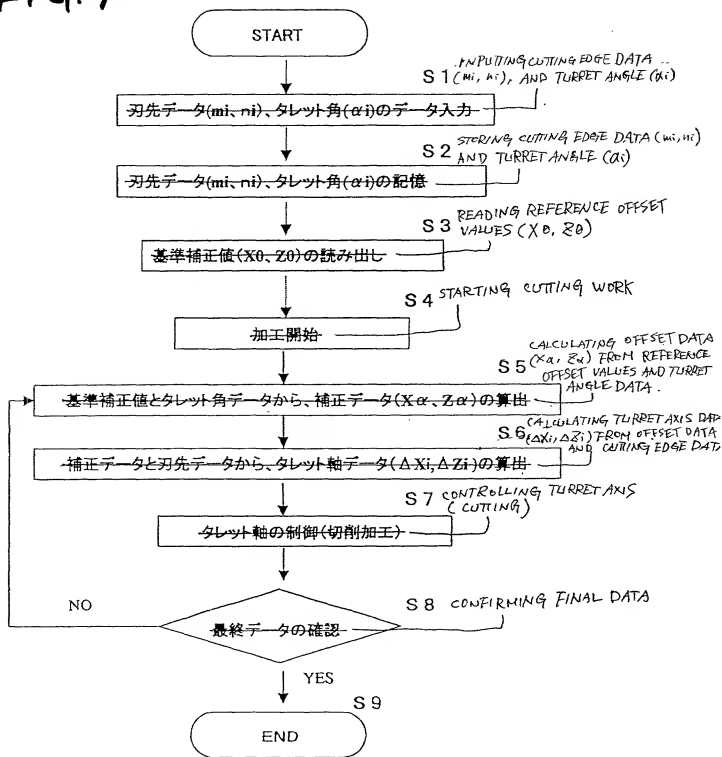


FIG. 5

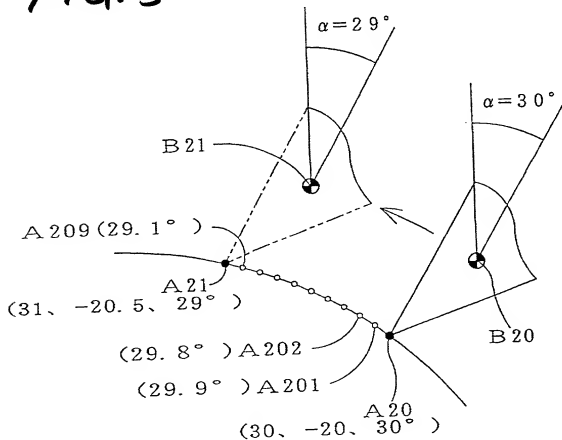
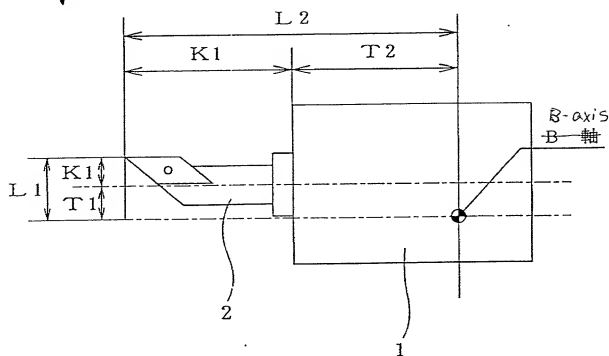


FIG. 6



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FIG. 7

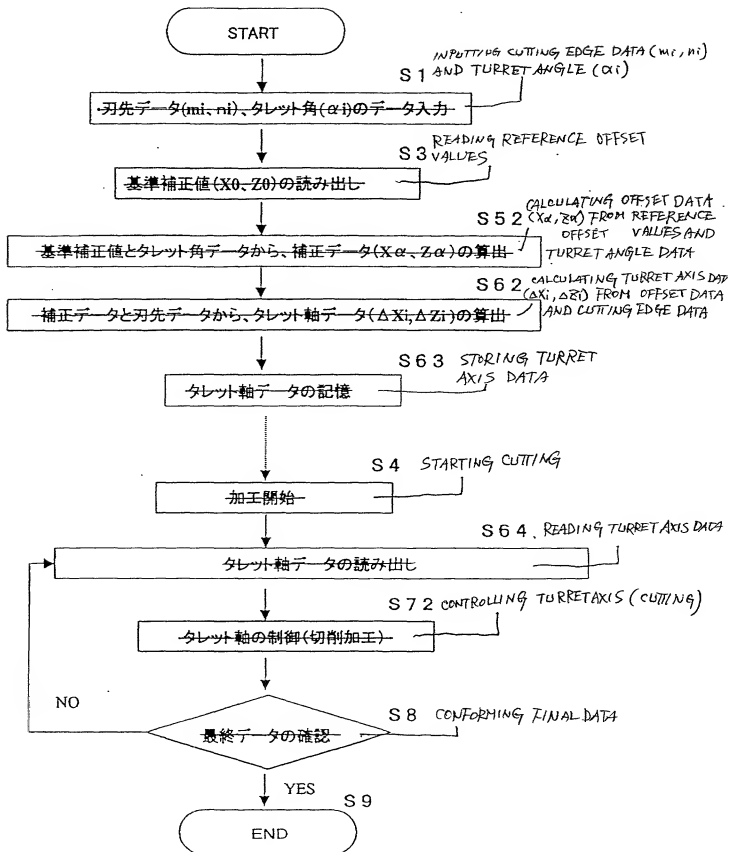
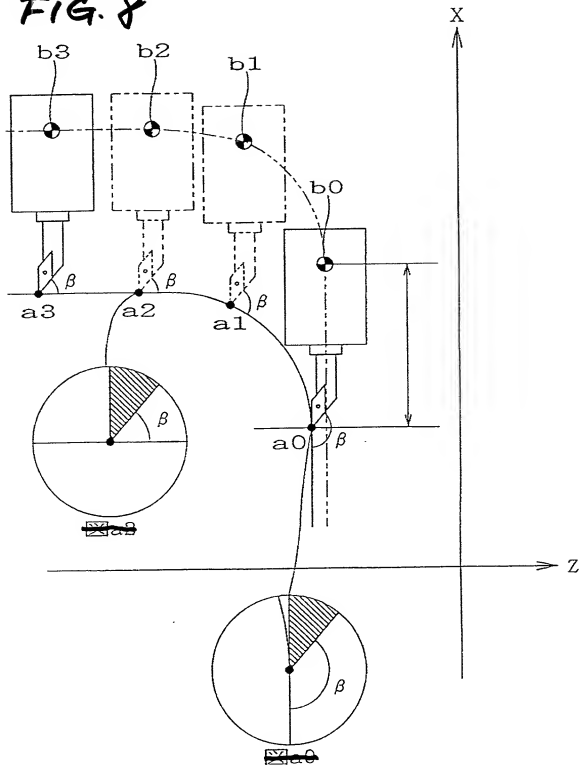


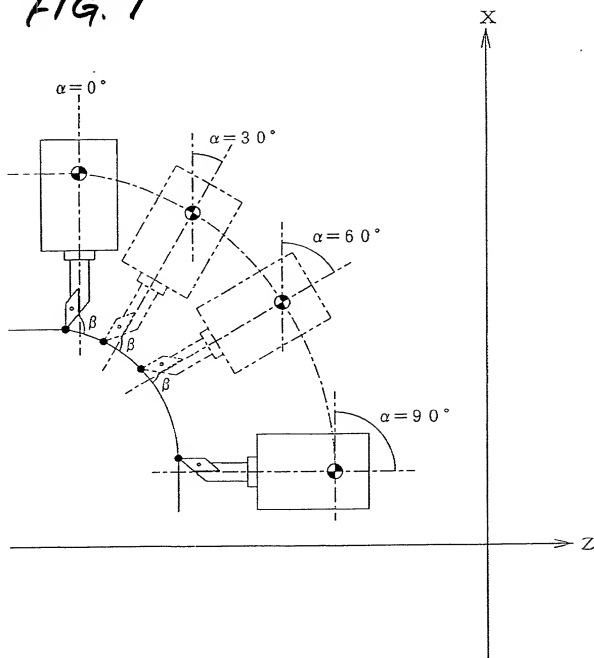
FIG. 8



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FIG. 9



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